


- NOTES:
1. THIS DRAWING IS FOR EXPLOSIVE BONDING USE ONLY.
  2. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
  3. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
  4. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
  5. ASSEMBLY SHALL BE ULTRASONICALLY TESTED AND CERTIFIED. CERTIFICATION OF ULTRA SONIC TEST SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATION
  6. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
  7. DIMENSIONS IN ( ) ARE FOR REF. ONLY

## \* MACHINE AFTER EXPLOSIVE BONDING

2	.31 [7.87] WAS .39 [10.01]			
	.717 [18.21] WAS .797 [20.25]			
	.966 [24.53] WAS .886 [22.50]			
	1.341 [34.06] WAS 1.181 [30.00]	M.J.M.		2/26/99
1	DRAWING BROUGHT UP TO DATE	M.J.M.		1/25/99
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC		QTY
PARTS LIST						
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER	THIS DRAWING IS THE PROPERTY OF			
TOLERANCES			ARGONNE NATIONAL LABORATORY			
DECIMALS	ANGULAR					
.X - .1 [2.5]	- 0°30'					
.XX - .01 [0.25]						
.XXX - .005 [0.13]						
SURFACE ROUGHNESS 125						
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.						
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1						
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5						
DO NOT SCALE DRAWING						
P2310102-02-1						
DRAWN BY MUSCIA		DATE 11/24/98	CHIEF DESIGN ENGINEER D. SHU	DATE 12/12/98	TITLE ADVANCED PHOTON SOURCE	
CHECKED BY SHU/CHANG		DATE 12/11/98	GP LEADER M. KUZAY	DATE 12/15/98	P2-30 APS UNDULATOR	
DESIGNER SHU/MUSCIA		DATE 11/24/98	PROJECT MGR.	DATE	FRONT END	
RESPONSIBLE ENGINEER D. SHU		DATE 12/12/98	APPROVED/RELEASED	DATE	PHOTON SHUTTER	
					LEFT HALF	
					</	